

Date: Thursday, 26/10/2006 1:16:18 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 29013					
Estimate Number	: 10709					
P.O. Number	: N/A		Part Number	: D32101		
This Issue	: 26/10/2006	S.O. No.	: N/A	Drawing Number	: D3210 REV A	
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: 29013		Material	: N/A		
Written By	:		Due Date	: 30/10/2006		
Checked & Approved By	:		Qty:	8	Um:	Each
Comment	: Est Rev:A New Issue 05-11-17 JLM					
	Est Rev:B Now On Waterjet 06-10-24 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet  26.1766
Comment:	Qty.: 2.6177 sf(s)/Unit Total : 20.9412 sf(s)	
Material:	2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify as D3210-1 ml8481 mla 1204 ⑧	
Batch:	M17695 M17695 ml 06/11/10	
2.0	WATER JET	FLOW WATER JET  ml a 12 04 ⑧
Comment:	FLOW WATER JET	
1-Cut as per Dwg D3210		
Dwg Rev:	AA A	
Prog Rev:	AA A	⑧
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  ml 06/11/11 ⑧
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK 
Comment:	SECOND CHECK	ml 06/12/04 ⑧ 06/12/04 ⑧
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment:	SMALL & MEDIUM FAB RESOURCE 1	 ml 06/12/04 ⑧
	Deburr	

Date: Thursday, 26/10/2006 1:16:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 29013

Part Number: D32101

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>YL 06/12/20 X 8</i>
7.0	POWDER COATING	POWDER COATING
	<i>M100700</i>	<i>(8X)</i>
	Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	<i>m-f/06/12/20</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>06/14/21 (8)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST89</i>	<i>06/14/21 (8)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>06/12/22 (8)</i>

Job Completion



LL 06/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/11	2.0	2 pieces scrap because Program holes was 0.128 but was supposed to be 0.141	as1042	Scrap 3. Destroy replace 2 pieces	MM 06/11/11	as1042	as1042	07.01.02
06/11/13	3	8 parts scrap due to wrong DXF	as1042	destroy and replace	MM 06/11/13	as1042	as1042	07.01.02

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:01:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 29013					
Estimate Number	: 10709					
P.O. Number	:			Part Number	: D32101	
This Issue	: 10/16/2006		S.O. No.	: D3210 REV A		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	: 25251			Material	:	
Written By	:			Due Date	: 10/30/2006	
Checked & Approved By	: <i>JL 061016</i>			Qty:	8	
Comment	: Est Rev:A New Issue 05-11-17 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
		Comment: Qty.: 2.6177 sf(s)/Unit Total : 20.9412 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify as D3210-1 Batch: _____
2.0	SHEAR	SHEAR
		Comment: SHEAR Cut blanks: 20.200" x 17.780" (+0.000/-0.010)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3210-1 as per Folio FA347 and Dwg D3210 Stack of 4
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK

DART AEROSPACE LTD

Work Order: 29013

Description: Doubler

Part Number: D3210-1

Inspection Dwg: 13210 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X

x Prototype

Measured by:

1901-1902

Audited by:

Prototype Approval:

Date -

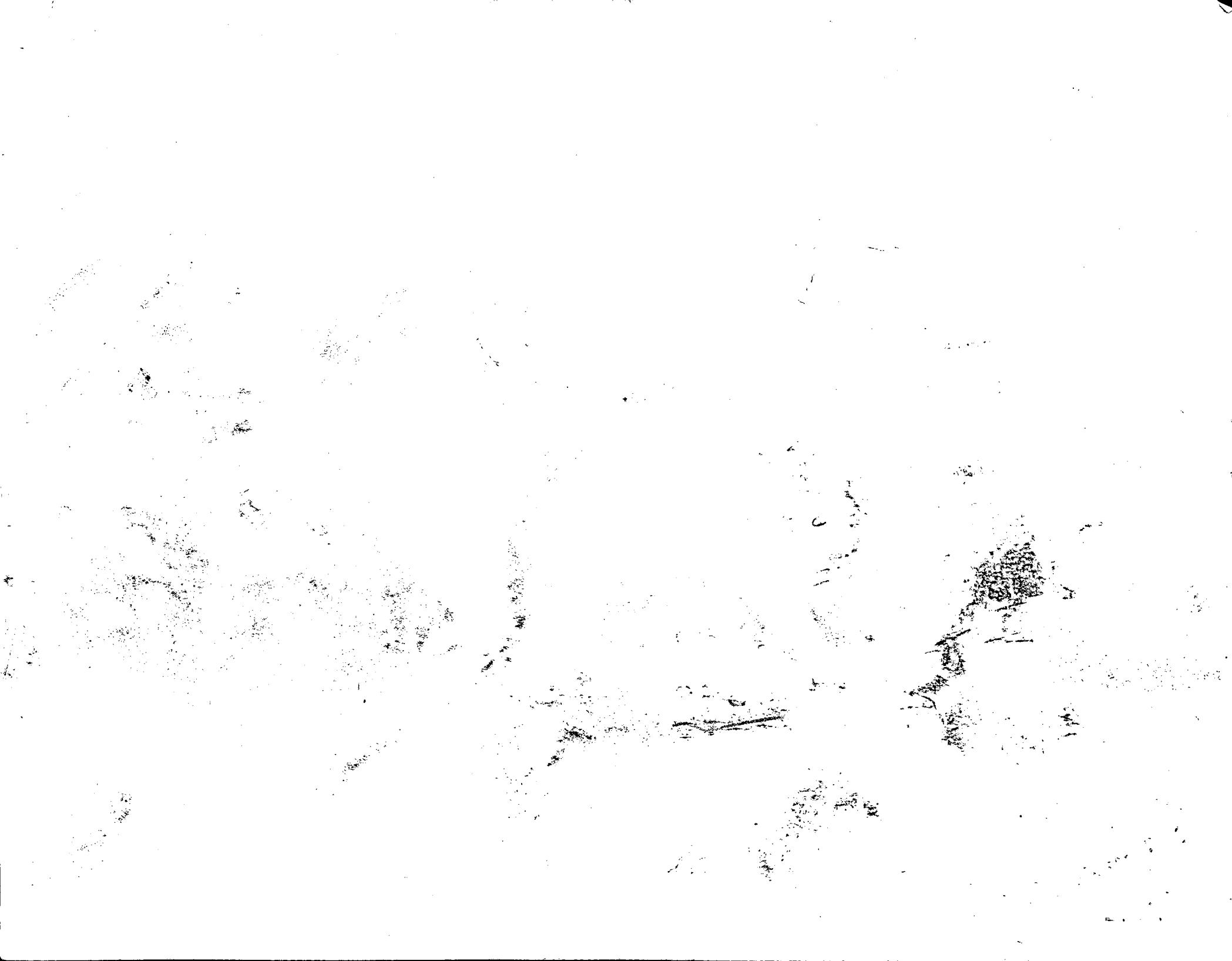
Date: 8/20/04

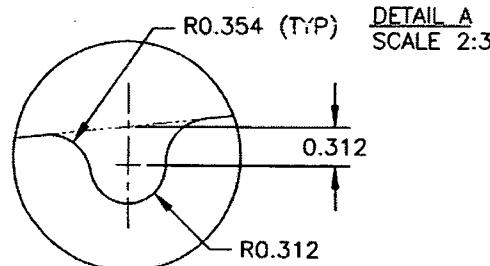
Date -

06/13/04

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





DETAIL A
SCALE 2:3

RELEASED
03.09.03

D3210-1 DOUBLER

MAKE PER DRAWING FILE "D3210-A1.DWG"

CHECK PER TEMPLATE D3210-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

©COPY (S)
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3210
DATE		SHEET 1 OF 1
03.09.03		TITLE DOUBLER
A	03.09.03	SCALE 1:3
	NEW ISSUE	

